



Dart Aerospace Ltd.
1270 Aberdeen St
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D5634-041BENT
Job Sheet 199963



Part No: D5634-041BENT

Job Qty: 1 pcs

Part Name: Float Skidtube Assembly, Bent



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/5/19

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 9/19/19

Description:

Type: Stock

Note: DWG D5634 REV.A IPP REV:A 19.01.17 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - Bend - 1	1 pcs	9/19/19	9/19/19	0.50	0.22	Skidtubes - Bend		MAG
120	QC 5	1 pcs	9/19/19	9/19/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		ALB
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
130	Packaging 3-1 - Stock - B4B	1 pcs	9/19/19	9/19/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		



Container No: S212350



Part: D5634-041BENT

Job No: 199963

Serial No/Batch: S212350

Revision: A

Inspector:

Exp Date:

Instructions:

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Hawkesbury, ON K6A 1K7
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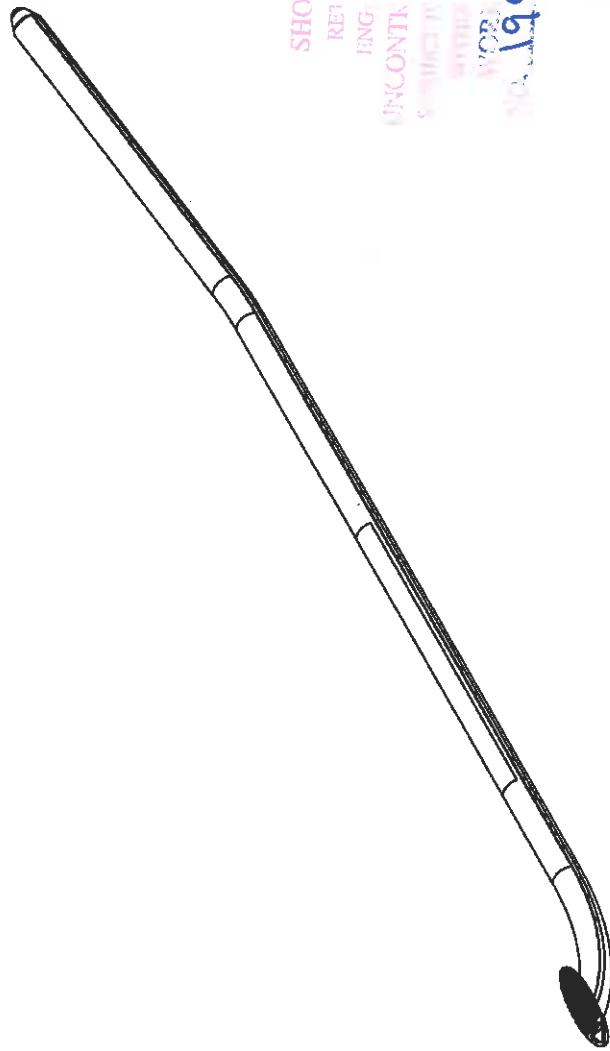
Date: 09/10/19

Plex 9/5/19 10:14 AM Dart.lajeunesse.marie

				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BE
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	Dec
				Packaging 3 - 36 - B4B	21
140 QC 21 - SA	1 pcs	9/19/19	0.00 0.00	QC 21 - SA - 21	9-30
				QC 21 - SA - 70	
Part Op 110 - ****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE**** 1- Bend FWD end of tube using bend prog D5634 Descriptions: FWD and folio _____ as per dwg D5634, cut fwd end of tube with saw table setup D5634 . 2- Test fit FWD cap. 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Identify as per dwg & Stock Location: <u>LG002</u>) LOCAITON : LG002 140 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
D2600-1-190	Extrusion Round 3" 206	1 pcs (1 ea)	110-Skidtubes - Bend - 1	<u>81081169</u> <u>B 108169</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
110-Skidtubes - Bend - 1	D2600-1-190	1	25	0	
Part Specifications					
Specifications could not be found.					

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QTY	PART NUMBER	DESCRIPTION
X	D5634-041	FLOAT SKIDTUBE ASSEMBLY
1	D2846	AFT CAP
7	D3275-1	SPACER
23	D4720-1	SPACER
1	D5633-1	TOW STEP
1	D5634-1	FLOAT SKIDTUBE
1	D5638-041	FLOAT WEB ASSEMBLY
2	MS24693-C272	SCREW, CSK 100°



D5634-041 FLOAT SKIDTUBE ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME PER DART QSI 005 4.2.1.3.3 (FLOAT SKIDTUBE PRIMER)
PAINT GLOSS BLACK PER DART QSI 005 4.2.2.4 (FLOAT SKIDTUBE PAINT)
BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044 8.4 ON INNER TUBE SURFACE AT AFT END.
 - 7) WEIGHT: 21.03 lb
 - 8) SEAL MATING SURFACES WITH SIKAFLEX -241/-291 OR PROSEAL P/S 8801/422 OR MIL-S-8802 CLASS B2 SEALANT
 - 9) INSTALL FASTENERS WET WITH SIKAFLEX -241/-291 OR PROSEAL P/S 8801/422 OR MIL-S-8802 CLASS B2 SEALANT
 - 10) INSTALL WEB INTO OUTER TUBE WITH SIKAFLEX -241/-291 ADHESIVE PER DART QSI 015.
 - 11) LOCATE AS SHOWN, ENSURE DOUBLER END IS LOCATED AT AFT BEND REGION
DAMAGE TO SURFACE ON BENDS
DAMAGE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 6" ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT WRINKLES UP TO 0.02" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.180" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
12) WEELDING PER QSI 005
 - 13) IT IS PERMISSIBLE TO GRIND SKIDTUBE TO IMPROVE FT WITH TOW STEP. DIMENSIONS SHOWN AFTER GRINDING FOR TOW STEP.
 - 14) SLOT FOR D5633-1 TOW STEP THRU BACK WALL ONLY.

RELEASED

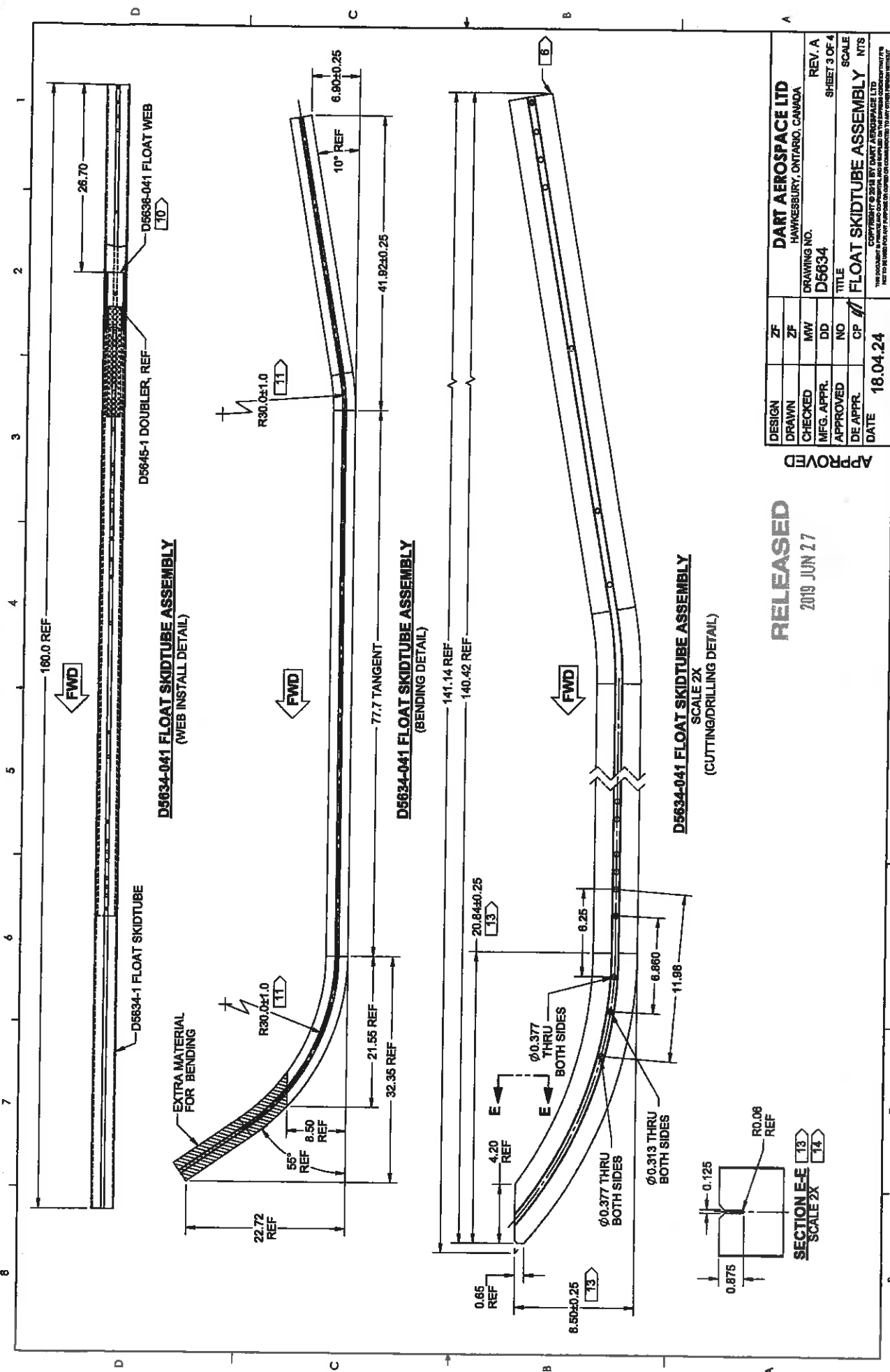
2013 JUN 27
E-LJ M-74L

APPROVED

REV.	NEW ISSUE	DESCRIPTION	ZF	BY	DATE
DESIGN					
DRAWN	ZF				
CHECKED	MW				
MFG. APPR.	DD				
APPROVED	NO				
DE APPR.	CP				
DATE	18.04.24				

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	REV. A
D5634	SHEET 1 OF 4
TITLE	SCALE
FLOAT SKIDTUBE ASSEMBLY	NTS

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DESIGN	ZF	ZF	DART AEROSPACE LTD
DRAWN	ZF	ZF	HAWKESBURY, ONTARIO, CANADA
CHECKED	MW	MW	DRAWING NO.
MFG. APPR.	DD	DD	D5634
APPROVED	NO	NO	TITLE
DE APPR.	CP	CP	SCALE
DATE	18.04.24	18.04.24	18.04.24

APPROVED

RELEASED

2019 JUN 27

REV. A

SHEET 3 OF 4

SCALE

NTS

THIS DOCUMENT IS UNCLASSIFIED

DATE 18.04.24

BY 18.04.24

FOR 18.04.24

REASON FOR DECLASSIFICATION

DATE OF REVIEW

REVIEWED BY

REVIEWED DATE

Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Machining ☐ Small Fab ☐ Large Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Supplier ☐ Water Jet ☐ Quality ☐																													
Date : _____		Sequence #: _____		QTY Affected : _____																													
Description Work Order Deviation 		Disposition 																															
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>				Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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Other/Details: _____																																	
		Completed By 																															
		Lead hand / Supervisor 																															
		QC / QA Coordinator 																															